

# Work Order ID 86560

**\*86560\***

Page 1

July-05-12 10:25:45 AM

Item ID: D3850-1KIV

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Hat Bin-Ivory

Start Date: 7/05/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/16/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3850

Rev C

100

0.00

**\*100\***

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Machine set up

2- Cut sheet to required blank size

105

0.00

**\*105\***

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°F

Time IN: 7:00 pm

Time OUT: 7:00 am

12/08/13

12/08/14

x/

x/

DL  
12/08/14

DL  
12/08/14

July-05-12 10:25:45 AM

Page 2

### Quality Control

# Work Order ID 86560

**\*86560\***

Page 3

July-05-12 10:25:45 AM

Item ID: D3850-1KIV Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Hat Bin-Ivory  
 Start Date: 7/05/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/16/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							DAS 07 8-89
<b>*140*</b>						x/			12/08/15
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1) Trim to Finished Dimensions								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 8-89
<b>*150*</b>						x/			12/08/15
QC	Memo	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>						/			
QC	Memo	0.00							
Quality Control									

SMB  
12-8-16

DAS  
16  
8-89 12/08/16

**Work Order ID 86560****\*86560\***

Page 4

July-05-12 10:25:45 AM

Item ID: D3850-1KIV

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Hat Bin-Ivory

Start Date: 7/05/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/16/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

MCS 12/08/24

MF  
12-08-24

# Picklist Print

July-05-12 10:25:44 AM

Page 1

Work Order ID: 86560

Parent Item: D3850-1KIV

Start Date: 7/05/12

Required Date: 7/16/12

Parent Item Name: Hat Bin-Ivory

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC  
Material 10/04/21 DL

IPP Rev B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MKYD6185S.125-P3-  
62015

Purchased

No

110

sf

838.6293

11.41

12.010526

6185 KYDEX .125"

Location

Loc Qty

Loc Code

therm

838.62929

838.62929

110426

12.01 = 9 qt.

12/08/15.

DAS  
07  
9-89

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 86560
<b>Description:</b> Hat Bin		<b>Part Number:</b> D3850-1KIV/KGY
<b>Inspection Dwg:</b> D3850	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DK Date: 12/08/14

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.55	Min	0.589"	✓		✓	DL-02
0.055	Min	0.100"	✓		✓	CAL-THERM
0.030	Min	0.035"	✓		✓	ULTRA

Measured by: DK Date: 12/08/15

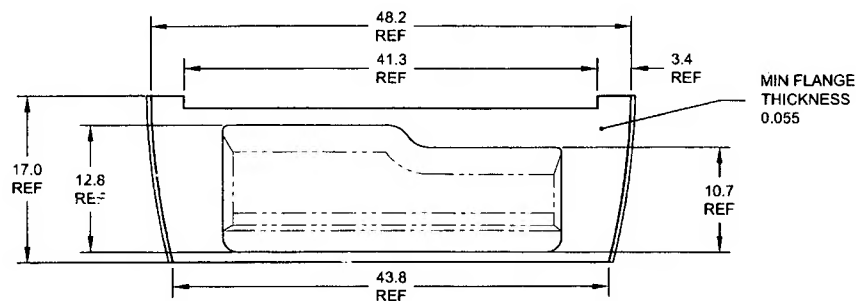
Audited by: DAS 16 12/08/15 Date:

Prototype Approval: N/A Date: N/A

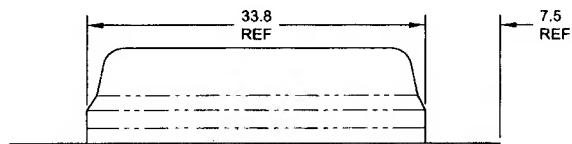
Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	

8 7 6 5 4 3 2 1

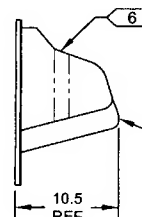
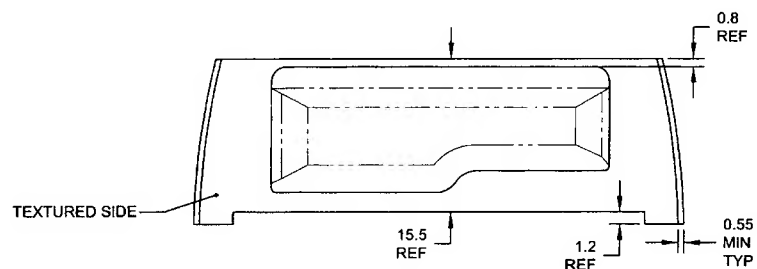
D



C



B



MIN THICKNESS IN DRAWN PORTION IS 0.030



RELEASED  
27/05/22

**D3850-1 HAT BIN**  
(BELL 206 L3/L4)

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9338 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3850-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3850-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3850-1KIV AND ADD STEEL GRAY P/N D3850-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3850	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN (BELL 206 L3/L4)	NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1